

452.1

Dart Aerospace Ltd.

Date: Monday, 5/15/2006 11:10:41 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 27104		
Estimate Number	: 11375		
P.O. Number	: N/A	Part Number	: D33871
This Issue	: 5/15/2006 S.O. No. : N/A	Drawing Number	: D3387 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 5/15/2006 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 26670	Material	: N/A
Written By	: <u>SEE COMMENT Below</u>	Due Date	: 5/30/2006
Checked & Approved By	: <u>06.05.15</u>	Qty:	20 Um: Each
Comment	: Est:A 05.08.10 New Issue KJ/JLM : Est:B 06.03.22 Split c'sink op. EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.5685 f(s)/Unit Total: 31.3698 f(s)
 6061-T6 Bar .50" x 6.0"
 Material: 6061-T6/T651 (QQ-A-200/8)
 (M6061T6B0.500x06.000)
 Identify for D3387-1
 Batch: ~~11/01/092~~ 11/01/092

SD 06.05.26 20

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 6.000" x 0.500" x 17.800" long

SD 06.05.26 20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA511 and Dwg D3387
 Identify as D3387-1
 Tumble and Deburr NO sharp edges

SD/JL 06/05/27 20



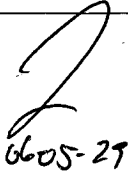

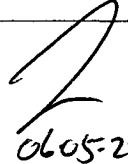
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 C'sink Ø0.375" as per Dwg D3387

06/05/29 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
0605-25	4	1 part C'sink elongated by 0.015. Part off on stopper.		C'sink acceptable. barley shows with screw installed & depth is good.	 06/05/29	 0605-29	 0605-29	 0605-29

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 0605/30

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Monday, 5/15/2006 11:10:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 27104

Part Number: D33871

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MB 06/05/29 20

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 06/05/29 20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA28

SE 06-05-29 20

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/05/30 (20)

Job Completion



U 06-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order: 27104
Description: Arm		Part Number: D3387-1
Inspection Dwg: D3387	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.125	+/-0.010	R.125	/			
0.125	+0.020/-0.000	.126	/			
Ø0.375 x100°	+/-0.010	Ø0.375x100°	/			
R0.032	+/-0.010	R.032	/			
0.500	+/-0.010	.503	/			
0.500	+/-0.010	.496	/			Mat. thickness
7.577	+/-0.010	7.579	/			
R0.125	+/-0.010	R.125	/			
Ø0.507	+0.000/-0.001	Ø.5065	/			
0.250	+/-0.010	.244	/			
1.347	+/-0.010	1.348	/			
2.000	+/-0.010	2.003	/			
1.000	+/-0.010	1.001	/			
Ø0.191	+0.005/-0.000	Ø.192	/			
R0.300	+/-0.010	R.300	/			
2.033	+/-0.010	2.033	/			
0.280	+/-0.010					
0.222	+/-0.010					
1.700	+/-0.010	1.704	/			

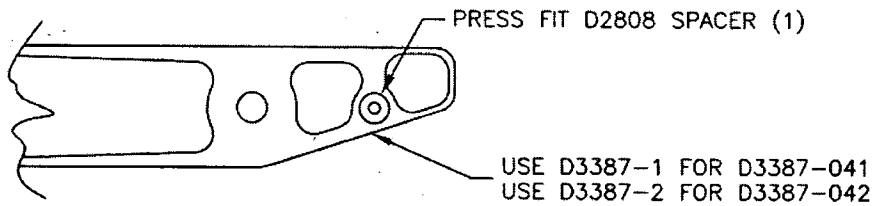
Measured by: SD	Audited by: J.F.	Prototype Approval:	N/A
Date: 06.05.26	Date: 06/05/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	

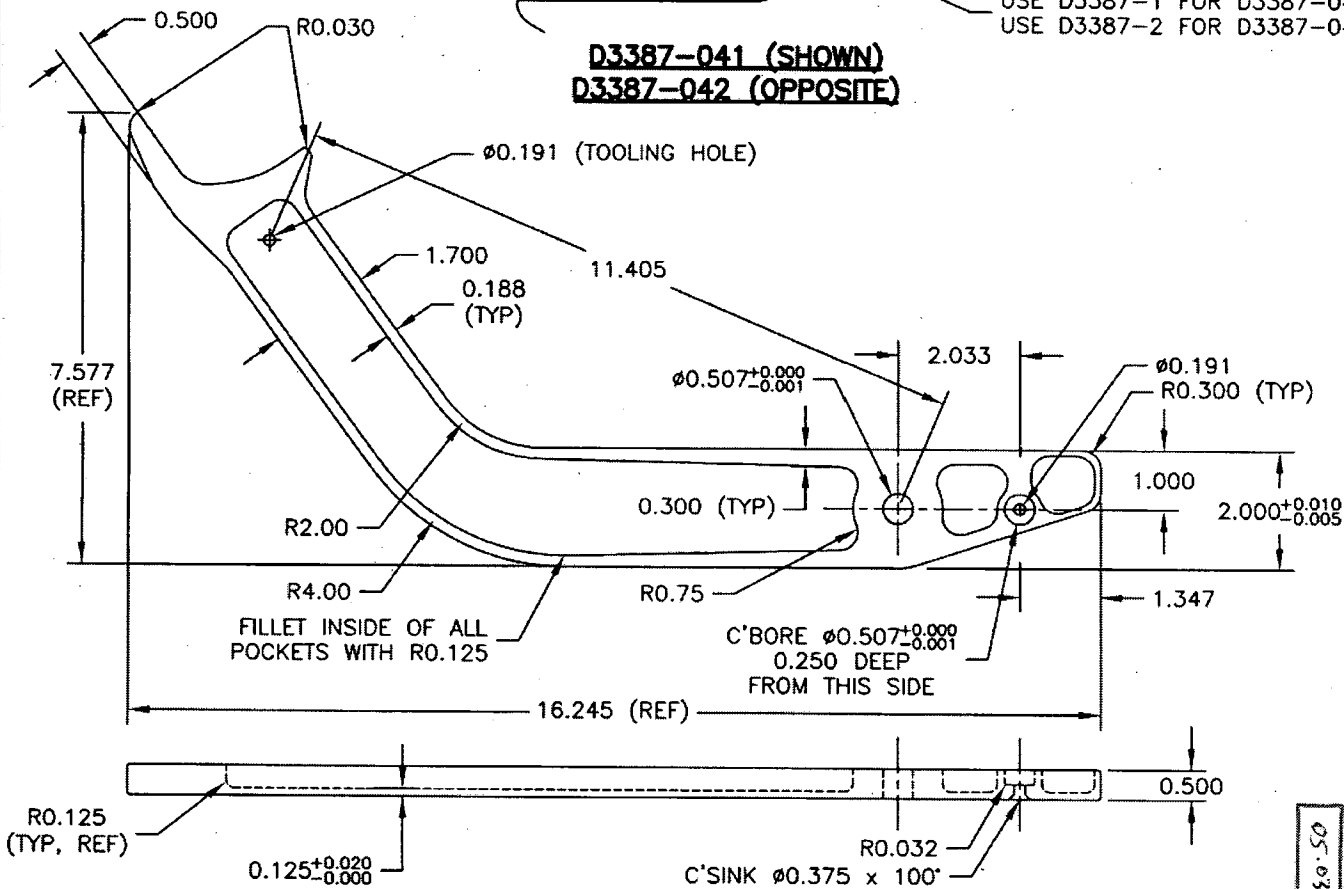


DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.01.18	DRAWING NO. D3387	REV. A
	TITLE ARM	SHEET 1 OF 1
A	05.01.18	NEW ISSUE
		SCALE 1:3

RELEASED
05.03.11



D3387-041 (SHOWN)
D3387-042 (OPPOSITE)



D3387-1 (SHOWN)
D3387-2 (OPPOSITE)

GENERAL NOTES

MACHINE PER DRAWING FILE "D3387-A.DWG"

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK
(REF DART SPEC. M6061T6B0.500)

DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 27104